

Work Order ID 60990

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Page 1

Item ID: D206-628-023

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step LH

Stop



Start Date: 8/03/10 Start Qty: 3.00



Cust Item ID:

Required Date: 8/12/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten initials

Date: 10-8-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-023 CHG 002

I put red labels on 8/10/13

CHG 002 8/10/13

10-8-03
(3)

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/8/13
40
\$

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/10/13

(x4)
41

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 60990

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Item ID: D206-628-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 8/03/10 Start Qty: 3.00



Cust Item ID:

Required Date: 8/12/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-628-023 □ Location: 71 □ PPP Rev: 4

10/8/13 SP

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/08/16 JD

U 10-08-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60990

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 8/03/10


Required Date: 8/12/10

Start Qty: 3.00


Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--|--|-----------|----|--|--|-----|------|-----------|---|---|--|--|--|
| AN3C4A | | Purchased | No | | | 120 | Each | 1,892.000 | 3 | 9 | | | |
|  | | | | | | | | | | | | | |
| BOLT | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST350 | 1892 | |
| 114108 | 14 | |
| 114416 | 12 | |
| 114523 | 2 | |
| 114941 | 864 | |
| 115300 | 1000 | |

| | | | | | | | | | | | | | |
|--|--|-----------|----|--|--|-----|------|---------|---|----|--|--|--|
| AN4C14A | | Purchased | No | | | 120 | Each | 89.0000 | 4 | 12 | | | |
|  | | | | | | | | | | | | | |
| Bolt | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST358 | 89 | |
| 111902 | 89 | |

| | | | | | | | | | | | | | |
|--|--|-----------|----|--|--|-----|------|----------|---|----|--|--|--|
| AN4C15A | | Purchased | No | | | 120 | Each | 124.0000 | 8 | 24 | | | |
|  | | | | | | | | | | | | | |
| Bolt | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST358 | 124 | |
| 111819 | 1 | |
| 113595 | 11 | |
| 113603 | 10 | |
| 114330 | 2 | |
| 114442 | 50 | |
| 114523 | 50 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Work Order ID: 60990

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 8/03/10

Required Date: 8/12/10

Start Qty: 3.00

Required Qty: 3.00

AN960C10 NAS1149C0363 Purchased No

120 Each 0.0000 3 9



WASHER

AN960C416L

Purchased No

120 Each 820.0000 24



WASHER

Location Loc Qty Loc Code

FG 44

104925 44

ST346 776

106785 38

107008 10

112794 287

112828 400

69220 41

D2731-7 Manufactured No

120 Each 83.0000 4



Mounting Lug

Location Loc Qty Loc Code

ST470 83

52330 35

55773 8

59202 40

D2732 Manufactured No

120 f 331.0410 2



Rubber Extrusion

Location Loc Qty Loc Code

ST412 331.041

56516 331.041

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84
5
x2
11/13524 10/8/13 84
72
96
10/8/13 81
12
10/8/13 81
10
10/8/13 81 8 feet (24)
30x

→ measure Diagonal
x2 per kit @ 3.0" long
10/10/13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60990

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 8/03/10

Required Date: 8/12/10

Start Qty: 3.00

Required Qty: 3.00

| | | | | | | | | | |
|---|--------------|----|---|-----|------|---------|---|----|--|
| <div>④</div> <div>D2842-041</div> <div><div>S</div><div>Step Assembly, 206 Float</div></div> <div>D2844-1</div> <div><div>S</div><div>x4Arm</div></div> | Manufactured | No | | 120 | Each | 0.0000 | 1 | 3 | <div>B60991</div> <div>10/8/13SP</div> |
| <div>D2844-3</div> <div><div>S</div><div>x4Arm</div></div> | Manufactured | No | <div>ST265</div> <div>52030</div> | 120 | Each | 16.0000 | 2 | 6 | <div>10/8/13SP</div> |
| <div>D3394-043</div> <div><div>S</div><div>x4Lug Assembly</div></div> | Manufactured | No | <div>ST265</div> <div>50825</div> | 120 | Each | 10.0000 | 1 | 3 | <div>10/8/13SP</div> |
| | Manufactured | No | <div>ST475</div> <div>45365</div> <div>52331</div> <div>55772</div> | 120 | Each | 65.0000 | 4 | 12 | <div>10/8/13SP</div> <div>④</div> |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60990

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 8/03/10

Required Date: 8/12/10

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

120

Each

1,211.000

12

36



10/8/13 SP

Nut

6+1

Location

Loc Qty

Loc Code

| | | |
|--------|------|----|
| FG | 40 | |
| 104603 | 40 | |
| ST301 | 1171 | |
| 112492 | 25 | |
| 113069 | 8 | |
| 114348 | 338 | 48 |
| 114523 | 500 | |
| 114784 | 300 | |

NAS1515H3

Purchased

No

120

Each

134.0000

3

9



10/9/13 SP

Washer

5+1

Location

Loc Qty

Loc Code

| | | |
|--------|-----|--|
| ST277 | 134 | |
| 111268 | 134 | |

NAS1515H4L

Purchased

No

120

Each

888.0000

24

72



10/8/13 SP (42)

WASHER

5+1

Location

Loc Qty

Loc Code

| | | |
|--------|-----|----|
| FG | 40 | |
| 103691 | 40 | |
| ST277 | 848 | |
| 112492 | 223 | 96 |
| 114236 | 268 | |
| 114265 | 357 | |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

5.2 D206-628-013/-014/-023/-024/-033/-033 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

| Qty -013 | Qty -014 | Qty -023 | Qty -024 | Qty -033 | Qty -034 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|--------------|------------------------------------|
| X | | | | | | D206-628-013 | 206 A/B FLOAT STEP INST. LH |
| | X | | | | | D206-628-014 | 206 A/B FLOAT STEP INST. RH |
| | | X | | | | D206-628-023 | 206 L/L1/L3/L4 FLOAT STEP INST. LH |
| | | | X | | | D206-628-024 | 206 L/L1/L3/L4 FLOAT STEP INST. RH |
| | | | | X | | D206-628-033 | 407 FLOAT STEP INST. LH |
| | | | | | X | D206-628-034 | 407 FLOAT STEP INST. RH |
| 2 | 2 | | | 4 | 4 | D2731-3 | MOUNTING LUG |
| 2 | 2 | 4 | 4 | | | D2731-7 | MOUNTING LUG |
| 8 | 8 | 8 | 8 | 8 | 8 | D2732-030 | RUBBER CUSHION |
| 1 | | | | | | D2841-041 | FLOAT STEP ASSEMBLY LH |
| | 1 | | | | | D2841-042 | FLOAT STEP ASSEMBLY RH |
| | | 1 | | 1 | | D2842-041 | FLOAT STEP ASSEMBLY LH |
| | | | 1 | | 1 | D2842-042 | FLOAT STEP ASSEMBLY RH |
| | | 2 | 2 | 2 | 2 | D2844-1 | ARM |
| | | 1 | 1 | 1 | 1 | D2844-3 | ARM |
| 2 | 2 | | | | | D2845 | ARM |
| 2 | 2 | | | 4 | 4 | D3394-041 | MOUNTING LUG |
| 2 | 2 | | | 4 | 4 | *D3394-1 | *MOUNTING LUG |
| 4 | 4 | | | 8 | 8 | *MS35489-93 | *GROMMET |
| 2 | 2 | 4 | 4 | | | D3394-043 | MOUNTING LUG |
| 2 | 2 | 4 | 4 | | | *D3394-3 | *MOUNTING LUG |
| 4 | 4 | 8 | 8 | | | *MS35489-93 | *GROMMET |
| 2 | 2 | 3 | 3 | 3 | 3 | AN3C4A | BOLT |
| 4 | 4 | | | | | AN4C13A | BOLT |
| 4 | 4 | 4 | 4 | 8 | 8 | AN4C14A | BOLT |
| 4 | 4 | 8 | 8 | 4 | 4 | AN4C15A | BOLT |
| 2 | 2 | 3 | 3 | 3 | 3 | AN960C10 | WASHER |
| 24 | 24 | 24 | 24 | 24 | 24 | AN960C416L | WASHER |
| 24 | 24 | 24 | 24 | 24 | 24 | NAS1515H4L | WASHER |
| 12 | 12 | 12 | 12 | 12 | 12 | MS21043-4 | NUT |
| 2 | 2 | 3 | 3 | 3 | 3 | NAS1515H3 | WASHER |

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE